

Work Order ID 72550

Friday, July 29, 2011 8:40:27 AM



Page 1

Item ID: D3913-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wide Handle Plate

Start Date: 7/29/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

4Date: 7/29/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3913

Prog Rev: ADwg Rev: A

Deburr as required

B11-8-02(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Accept



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Stop



Item Name: Wide Handle Plate

Start Date: 7/29/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>WAS</u> Memo	0.00 0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11-08-3
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, July 29, 2011 8:41:17 AM

Page 1

Work Order ID: 72550



Parent Item: D3913-15



Parent Item Name: Wide Handle Plate


Start Date: 7/29/2011

Required Date: 8/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	71.0000	0.1068	0.337263			



B11-8-2

Location

Loc Qty

Loc Code

MAT020

71

117494

71

117494

(6)

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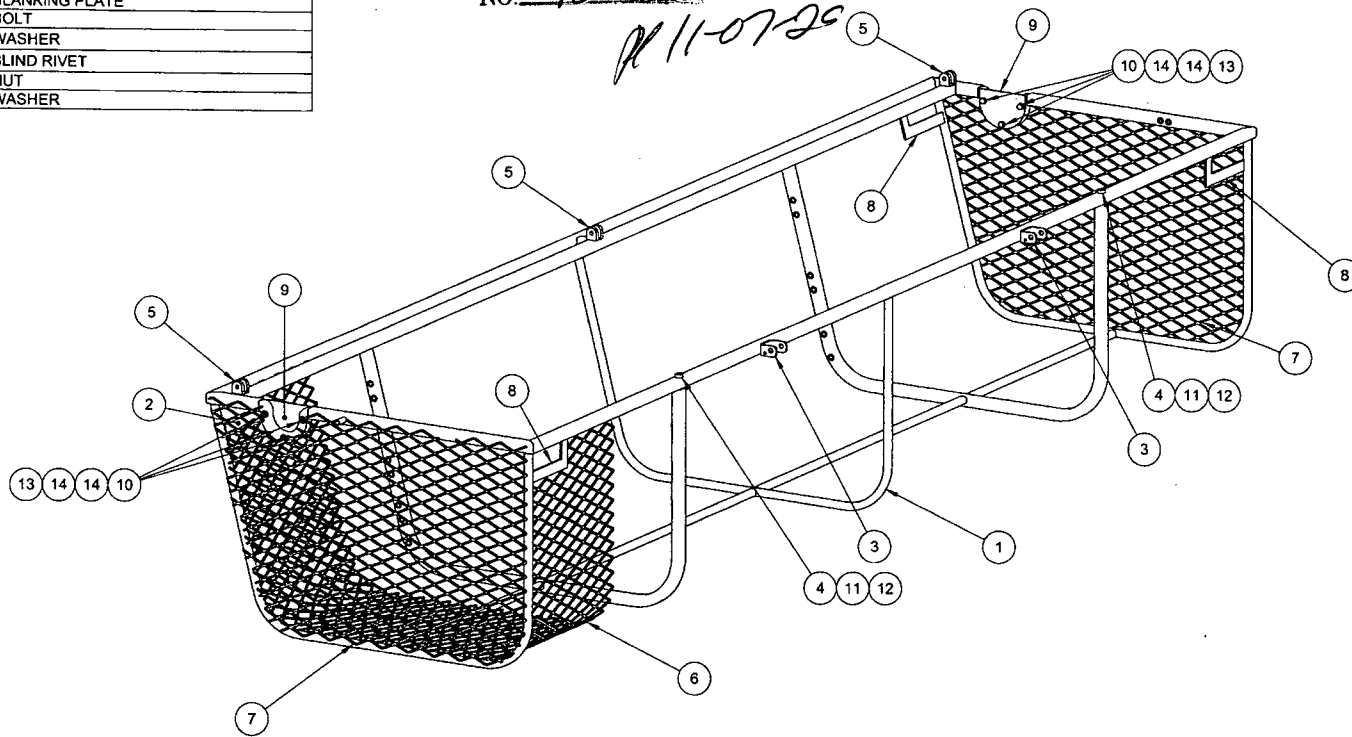
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOP COPY!
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 72550

11-07-20



D3913-041 LONG BASKET BASE ASSY (350)
 (MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
 2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) SCALE NTS	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.16	REV. A SHEET 1 OF 6 COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D
D8-2 C
D4020-1
MESH

30.00

34.50

2 PL

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL (8)

D2581
MOUNTING BRACKET
2 PL

D3913-101
TUBULAR ASSY

72550

0.75
D4021-1
HANDLE PLATE

A

45.94

45.94

D4016-1
HINGE HALF, BASE
3 PL

3 PL

D4021-1
HANDLE PLATE
2 PL

C7-3 A

C3-3 B

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350)	NTS
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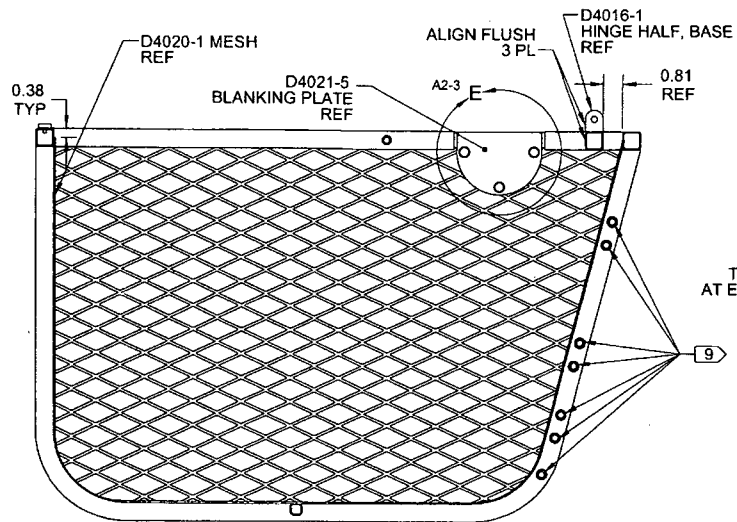
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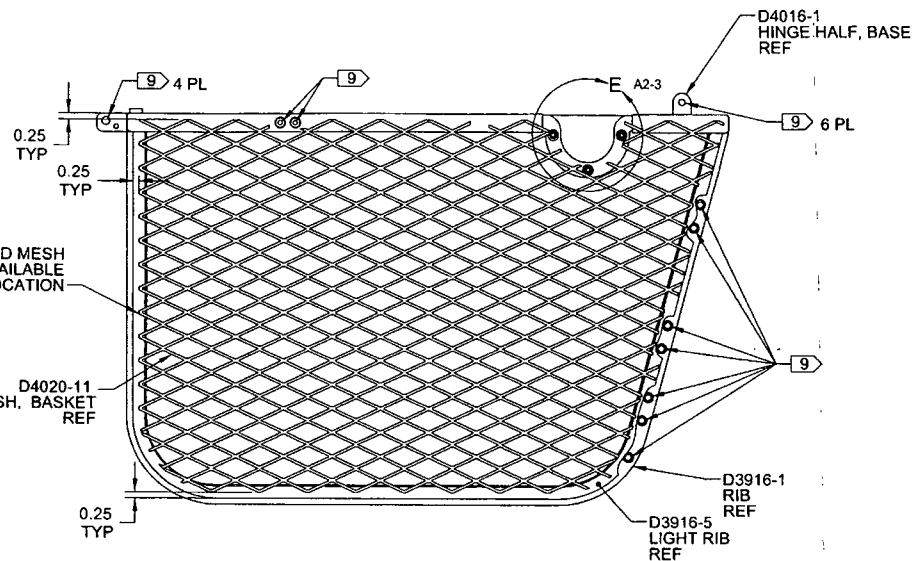
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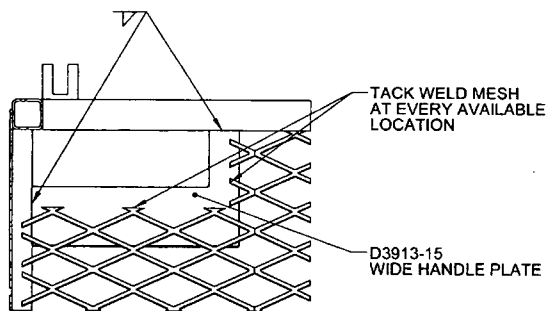
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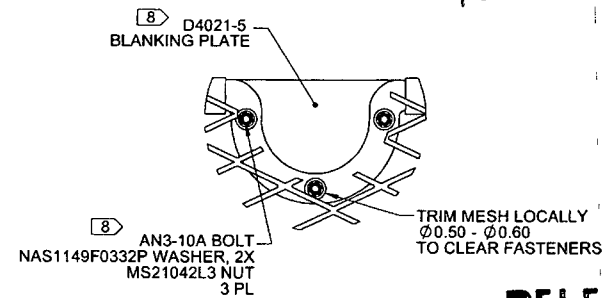
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

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CHECKED		DRAWING NO.	REV. A
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2010-03-22

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A

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2010-03-22

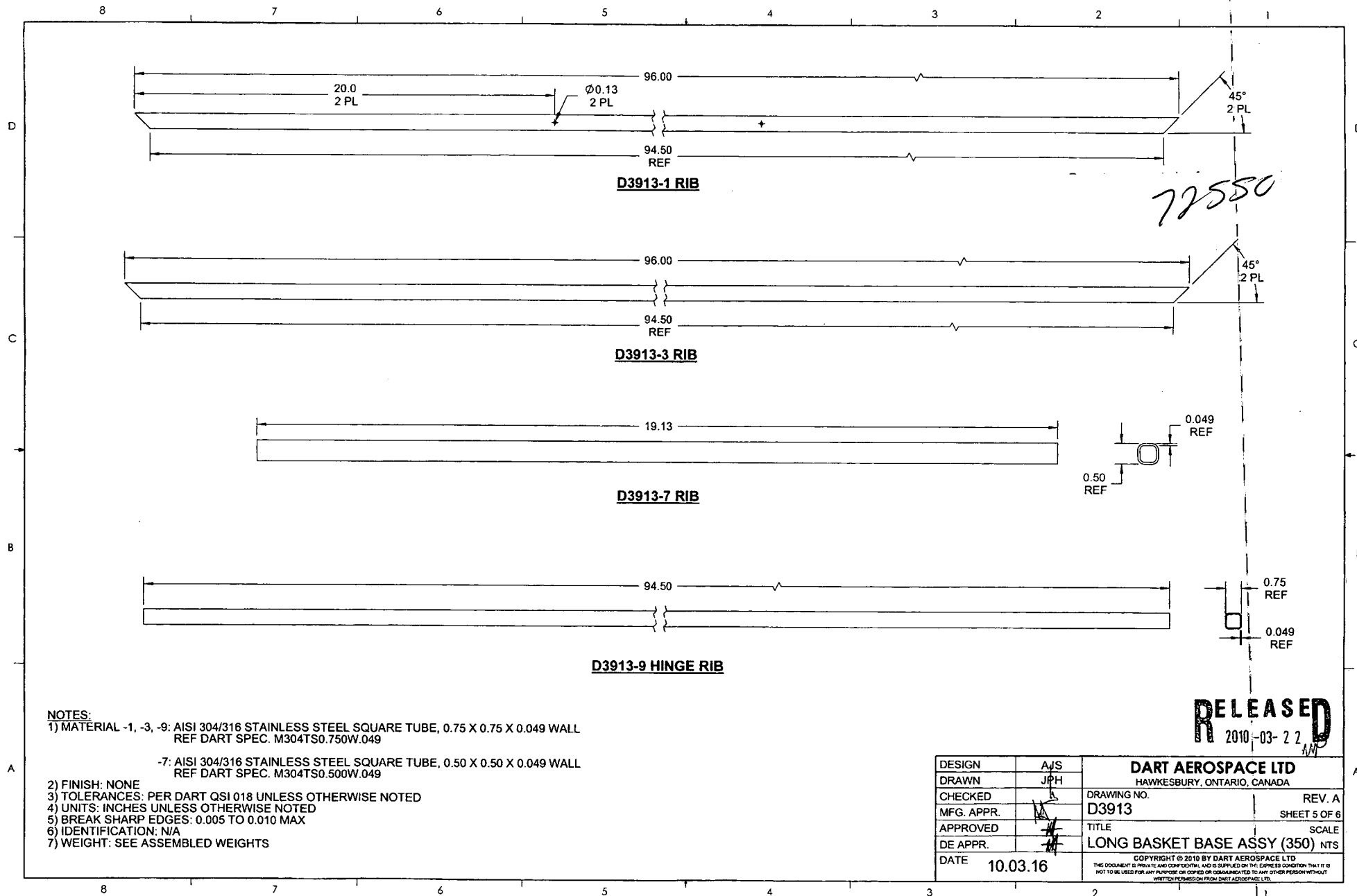
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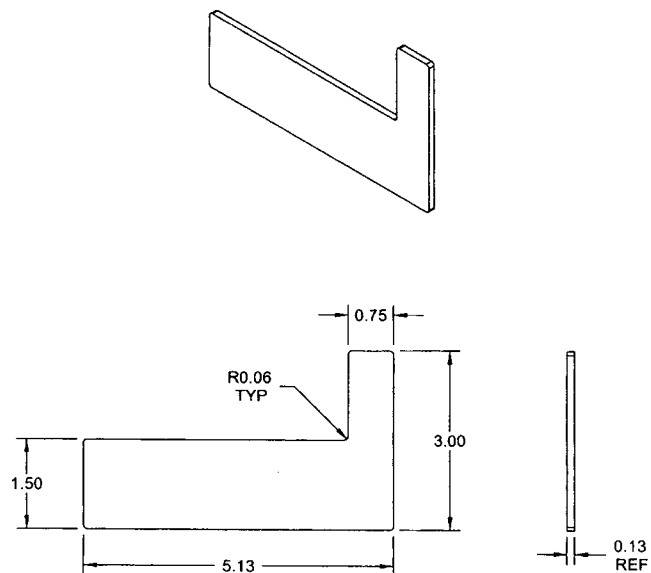
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 6 OF 6
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~~72550~~

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>11-8-2</u>	Date: <u>11/8/02</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	